

Order 11943



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5076-047
Job Sheet 188882



Part No: D5076-047

Job Qty: 4 pcs

Part Name: Fwd Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/16/19

Job Tracking No:

Due Date: 2/12/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: D5076 REV.B IPP REV:A 18.11.14 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	4 pcs	2/12/19		0.00	1.53	Small Fab - 1		DAS 58 FEB 26 2019 9-89
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	4 pcs	2/12/19		0.00	0.00	QC 5 - 10		DAS 68 FEB 26 2019 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
120	Packaging 3-1 - Stock - B4B	4 pcs	2/12/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	ST 617 FEB 26 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
130 QC 21 - SA	4 pcs	2/12/19	0.00 0.00	QC 21 - SA - 21	DAS 21 FEB 26 2019
				QC 21 - SA - 70	
Part Op 100 - Small Fab - ASSEMBLE AS PER DWG ***TORQUE SCREWS AS PER DWG NOTE*** Descriptions: 110 - QC5- Inspect part completeness to step on W/O 120 - Identify as per dwg & Stock Location: _____ 130 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
AN525-832R7	Screw	16 Ea (4 ea)	100-Small Fab - 1	S1432291	
D4434-045	Fwd Outboard Bracket Assembly	4 pcs (1 ea)	100-Small Fab - 1	S198427	
D5076-045	Fwd Inboard Bracket Assembly	4 Ea (1 ea)	100-Small Fab - 1	S156309	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Small Fab - 1	AN525-832R7	16	135	0	
	D4434-045	4	0	0	
	D5076-045	4	0	0	
Part Specifications					
Specifications could not be found.					



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D5076-047

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Part Weight: 0 lbs

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Description:

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Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		2/12/19	0.00	0.00	Start Up Small Fab-4		
100	Small Fab	4 pcs		2/12/19	0.00	1.53	Small Fab-8		
110	QC	4 pcs		2/12/19	0.00	0.00	QC5		
120	Packaging	4 pcs		2/12/19	0.00	0.00	Packaging3-2		
130	QC21-SA	4 Ea		2/12/19	0.00	0.00	QC21		

Part Op Descriptions: **100** - ASSEMBLE AS PER DWG ***TORQUE SCREWS AS PER DWG NOTE***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN525-832R7	Screw	16 Ea (4 ea)	90-Start up Operation	
D4434-045	Fwd Outboard Bracket Assembly	4 Ea (1 ea)	90-Start up Operation	
D5076-045	Fwd Inboard Bracket Assembly	4 Ea (1 ea)	90-Start up Operation	

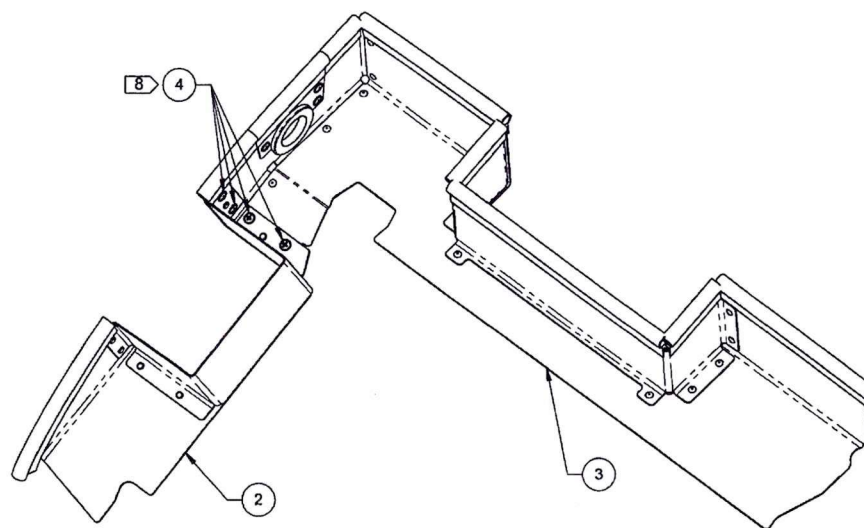
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN525-832R7	16	169	0
	D4434-045	4	9	0
	D5076-045	4	0	0

Part Specifications

Specifications could not be found.

ITEM	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D5076-041	FWD BRACKET ASSEMBLY
2	1	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
3	1	D5076-043	FWD INBOARD BRACKET ASSEMBLY
4	4	AN525-832R7	SCREW



D5076-041 FWD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.39 lbs
- 8) TORQUE SCREWS TO 12-15 (in-lb)

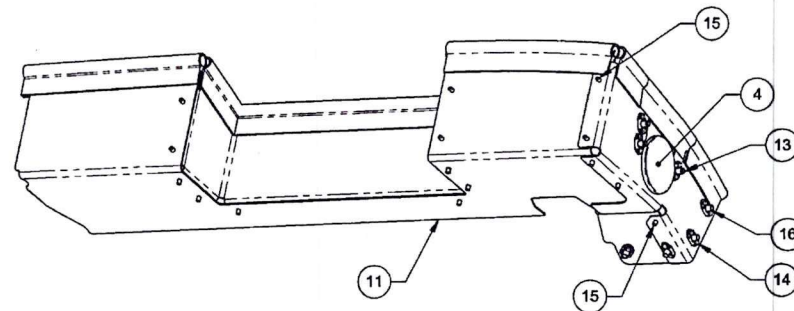
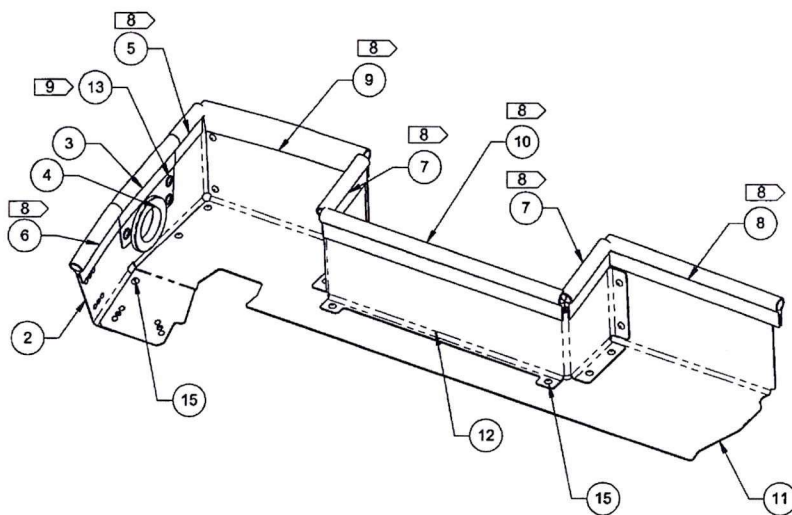
RELEASED

2010 OCT 19
EON 15-428 41

APPROVED

B	ADD D5076-5, D5076-045, D5076-047. REF PAR18-256	PM	18.09.24
A	NEW ISSUE	RF	14.03.11
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5076 REV. B SHEET 1 OF 12 TITLE BRACKET ASSEMBLY SCALE NTS COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	PM		
CHECKED	VS		
MFG. APPR.	DD		
APPROVED	VS		
DE APPR.	DS		
DATE	18.09.24		

ITEM	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D5076-043	FWD INBOARD BRACKET ASSEMBLY
2	1	D4434-9	BRACKET
3	1	D4435-041	BRACKET ASSEMBLY
4	1	D4440-1	GROMMET
5	1	D4441-1-017	RUBBER SEAL
6	1	D4441-1-025	RUBBER SEAL
7	2	D4441-1-026	RUBBER SEAL
8	1	D4441-1-067	RUBBER SEAL
9	1	D4441-1-064	RUBBER SEAL
10	1	D4441-1-094	RUBBER SEAL
11	1	D5076-1	BRACKET
12	1	D5076-3	BRACKET
13	3	AN525-832R6	SCREW
14	14	MS20426AD3-3	RIVET
15	15	MS20470AD4-3	RIVET
16	7	MS21075L08	NUT PLATE
17	A/R	3M 1300/1300L	ADHESIVE



D5076-043 FWD INBOARD BRACKET ASSEMBLY

NOTES:

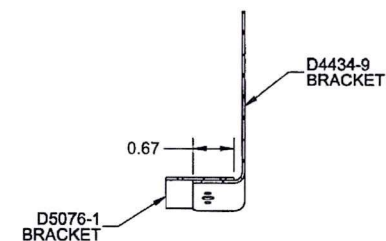
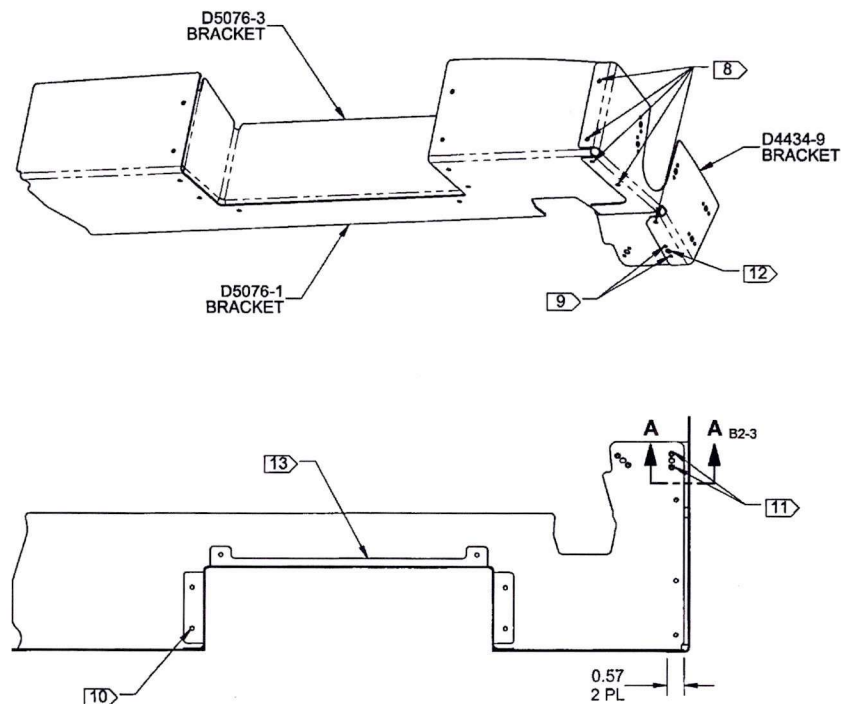
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3 PRIOR TO INSTALLING D4435-041.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.01 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
- 9) TORQUE SCREWS TO 12-15 (in-lb)

RELEASED

2018 OCT 19

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	PM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5076	SHEET 2 OF 1
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SECTION A-A C4-3

D5076-043 FWD INBOARD BRACKET ASSEMBLY
AUXILIARY VIEW

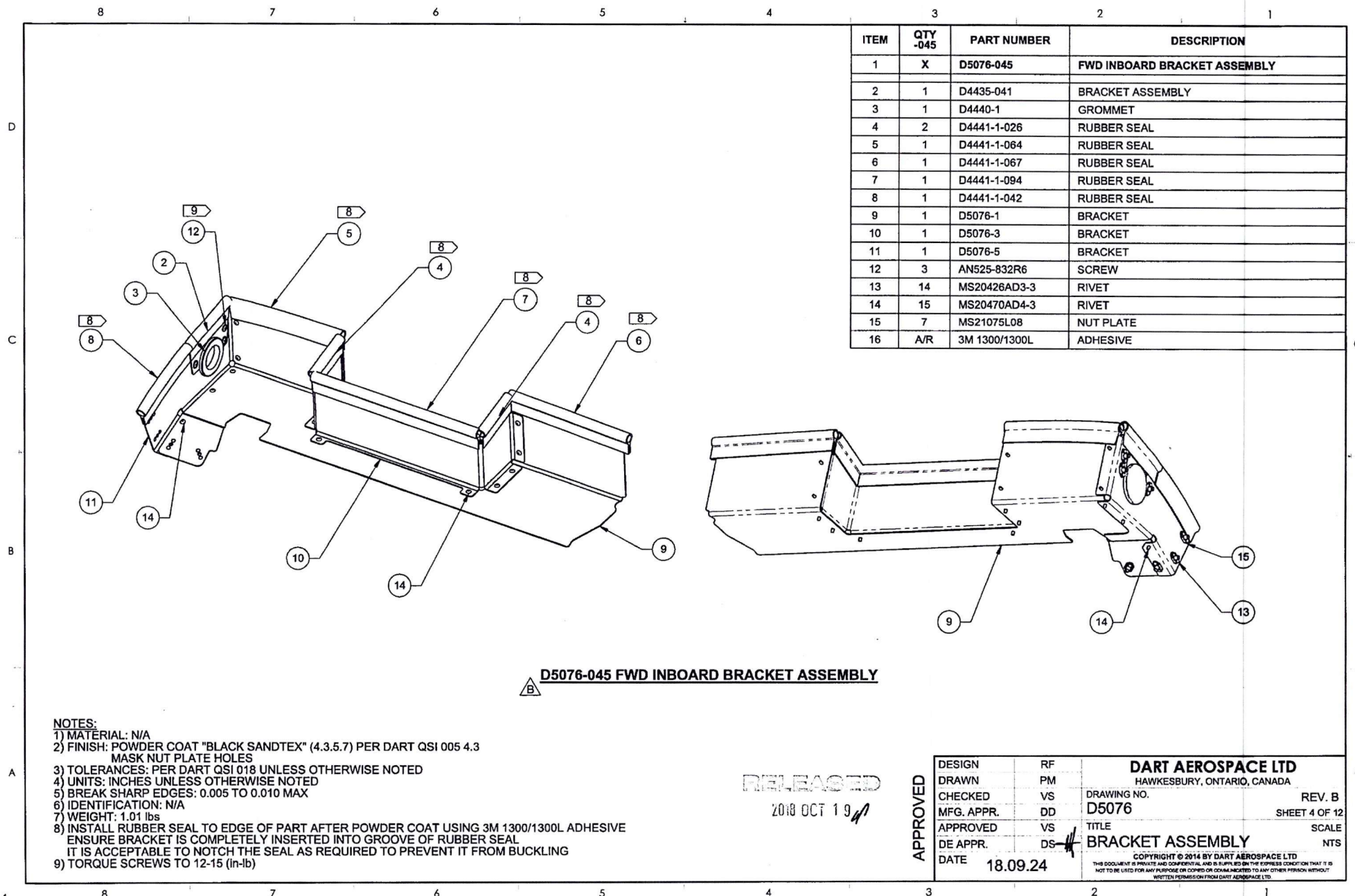
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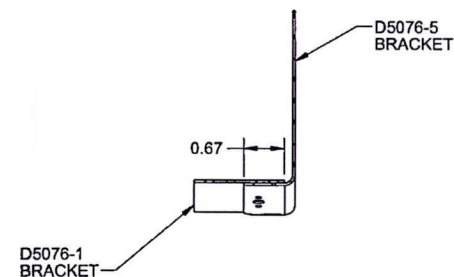
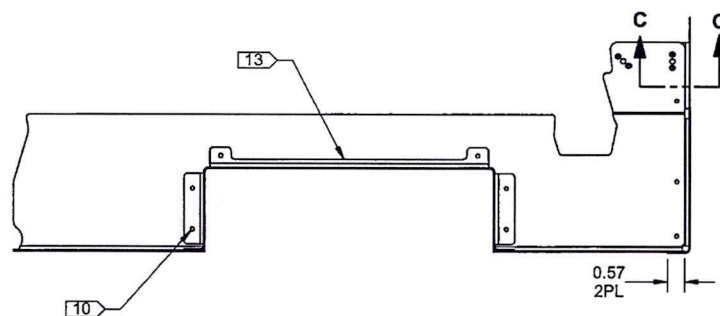
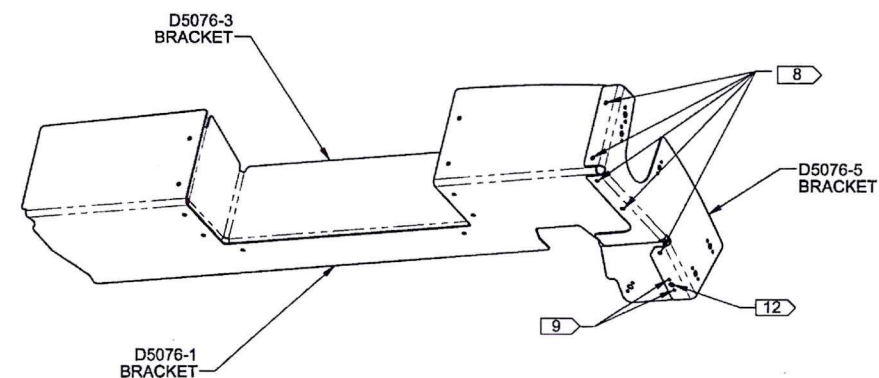
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.01 lbs
- 8) TRANSFER $\phi 0.129$ HOLES THRU 5 PLACES FROM D4434-9 TO D5076-1
- 9) TRANSFER $\phi 0.098$ HOLES THRU 2 PLACES FROM D4434-9 TO D5076-1
- 10) TRANSFER $\phi 0.129$ HOLES THRU 10 PLACES FROM D5076-3 TO D5076-1
- 11) CSK $\phi 0.179 \times 100^\circ$ ON THIS SIDE 2 PLACES
- 12) TRANSFER $\phi 0.177$ HOLE THRU FROM D4434-9 TO D5076-1
- 13) CENTRE D5076-3 INTO OPENING OF D5076-1

RELEASED
200 OCT 13

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DESIGN	RF	DART AEROSPACE LTD	
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MFG. APPR.	DD	D5076	SHEET 3 OF 12
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SECTION C-C

D5076-045 FWD INBOARD BRACKET ASSEMBLY
AUXILIARY VIEW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.01 lbs
- 8) TRANSFER $\phi 0.129$ HOLES THRU 5 PLACES FROM D5076-5 TO D5076-1
- 9) TRANSFER $\phi 0.098$ HOLES THRU 2 PLACES FROM D5076-5 TO D5076-1
- 10) TRANSFER $\phi 0.129$ HOLES THRU 10 PLACES FROM D5076-3 TO D5076-1
- 11) CSK $\phi 0.179 \times 100^\circ$ ON THIS SIDE 2 PLACES
- 12) TRANSFER $\phi 0.177$ HOLE THRU FROM D5076-5 TO D5076-1
- 13) CENTRE D5076-3 INTO OPENING OF D5076-1

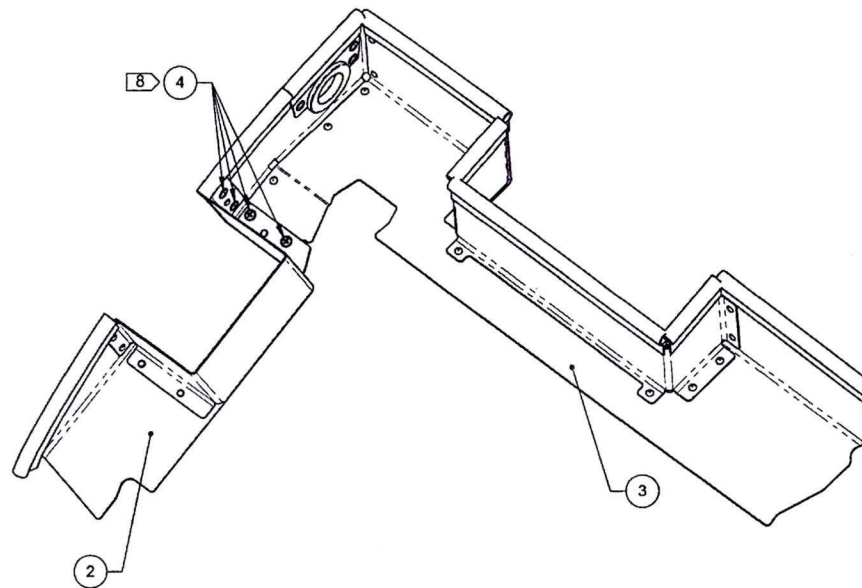
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2013 OCT 19

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	PM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5076	SHEET 5 OF 12
APPROVED	VS	TITLE	SCALE
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ITEM	QTY. -047	PART NUMBER	DESCRIPTION
1	X	D5076-047	FWD BRACKET ASSEMBLY
2	1	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
3	1	D5076-045	FWD INBOARD BRACKET ASSEMBLY
4	4	AN525-832R7	SCREW



D5076-047 FWD BRACKET ASSEMBLY

NOTES:

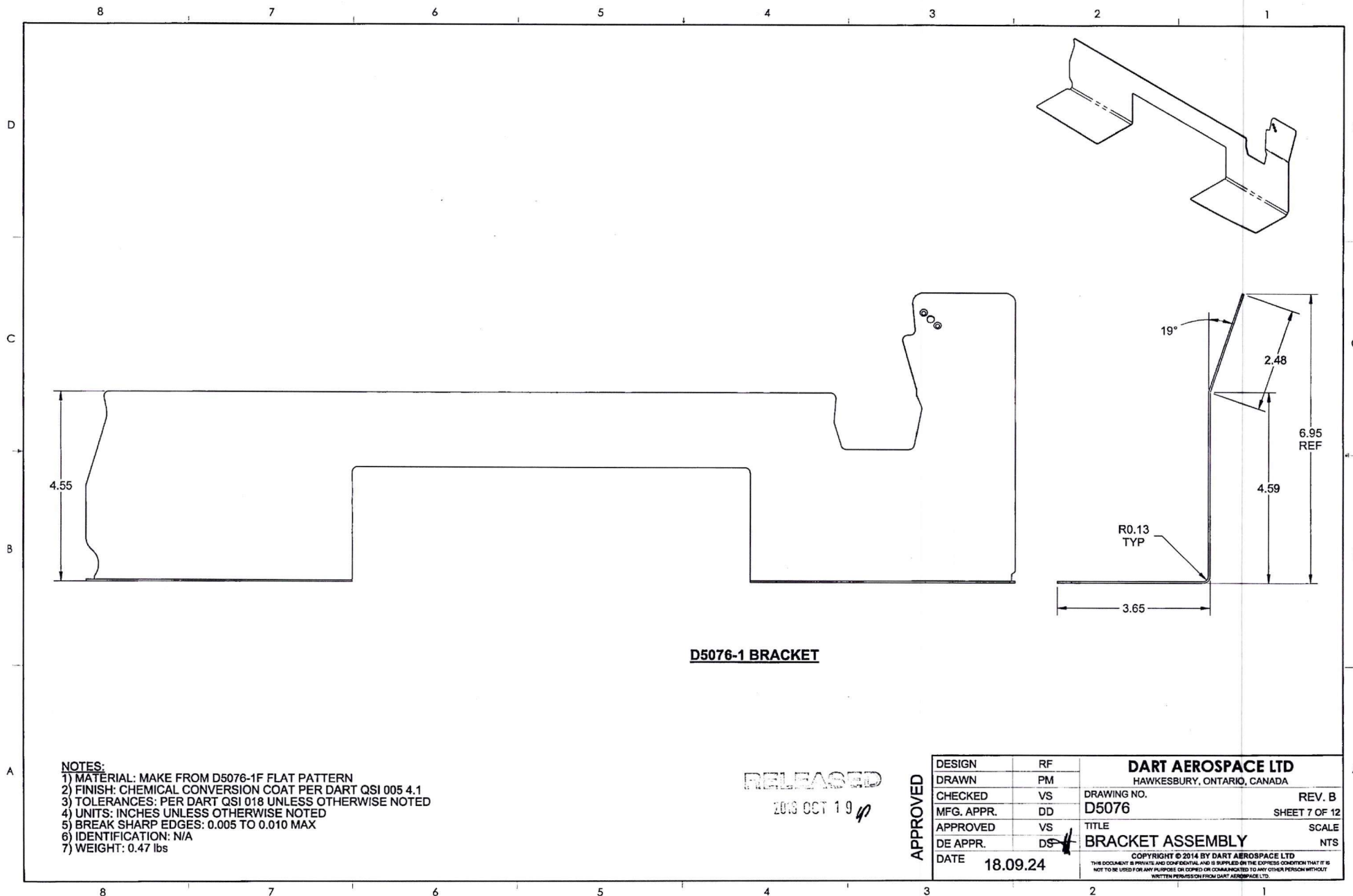
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.39 lbs
- 8) TORQUE SCREWS TO 12-15 (in-lb)

RELEASED

2019 OCT 19

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	PM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5076	SHEET 6 OF 12
APPROVED	VS	TITLE	SCALE
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D5076-1 BRACKET

NOTES:

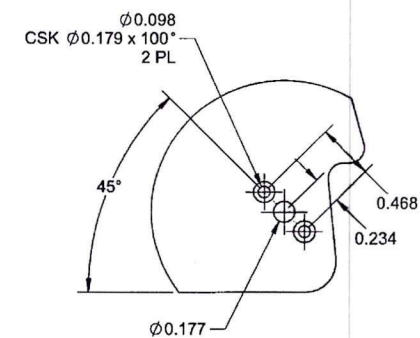
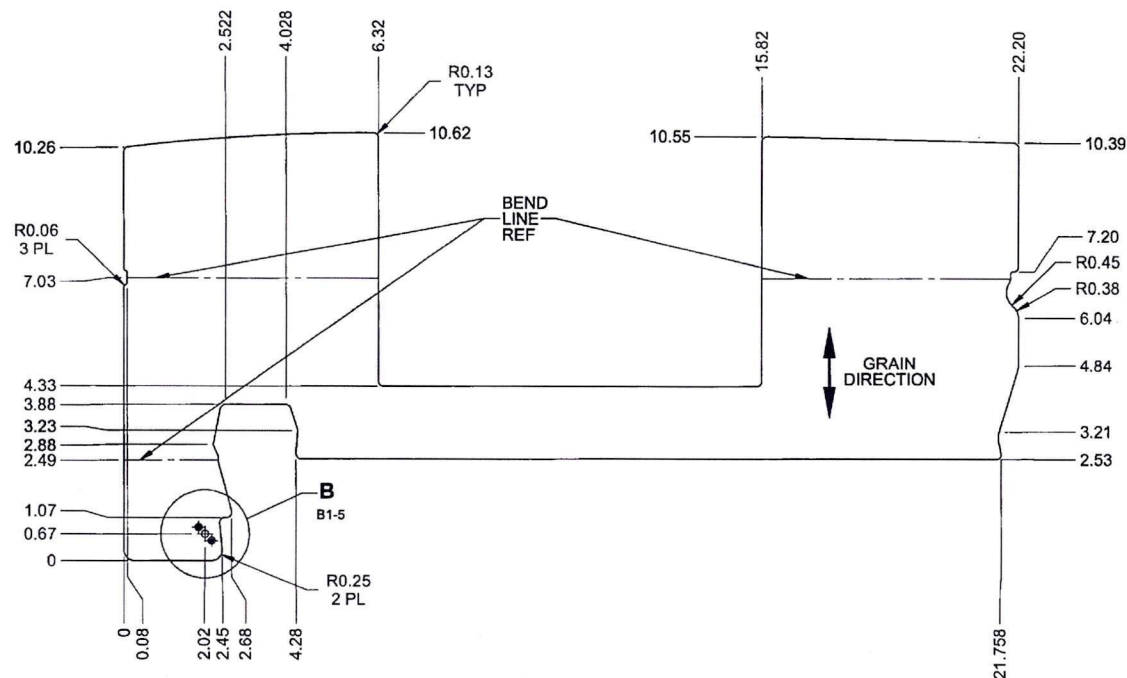
- 1) MATERIAL: MAKE FROM D5076-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

RELEASED

2013 OCT 19

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PM		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5076	SHEET 7 OF 12
APPROVED	VS	TITLE	SCALE
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D5076-1F FLAT PATTERN BRACKET

NOTES:

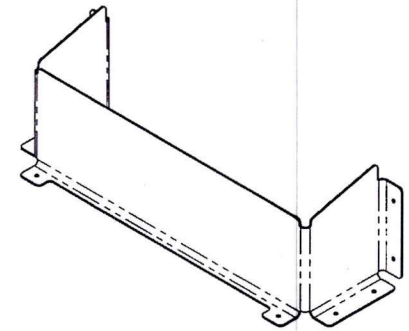
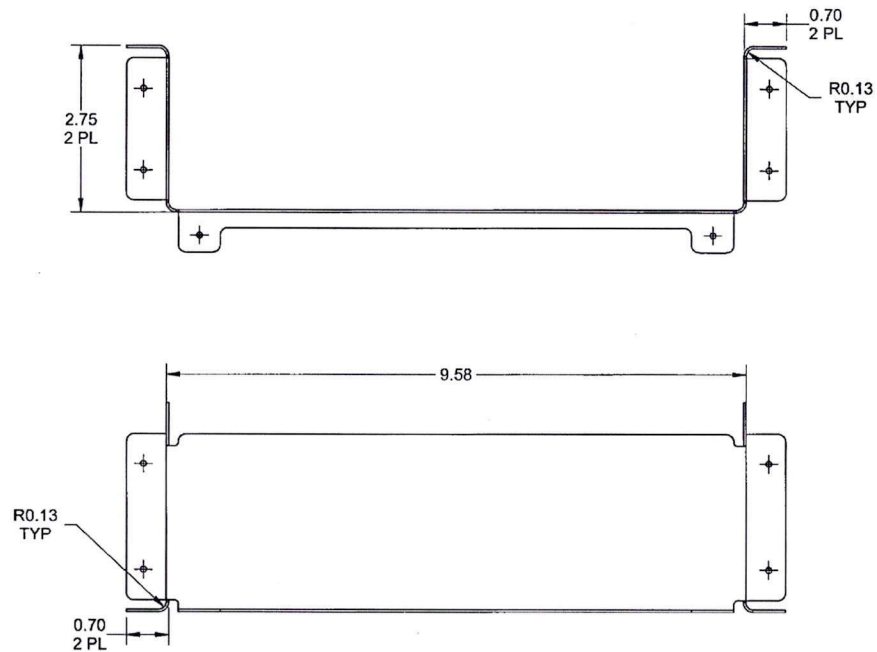
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

RELEASED

2015 OCT 19

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	PM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5076	SHEET 8 OF 1
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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D5076-3 BRACKET

NOTES:

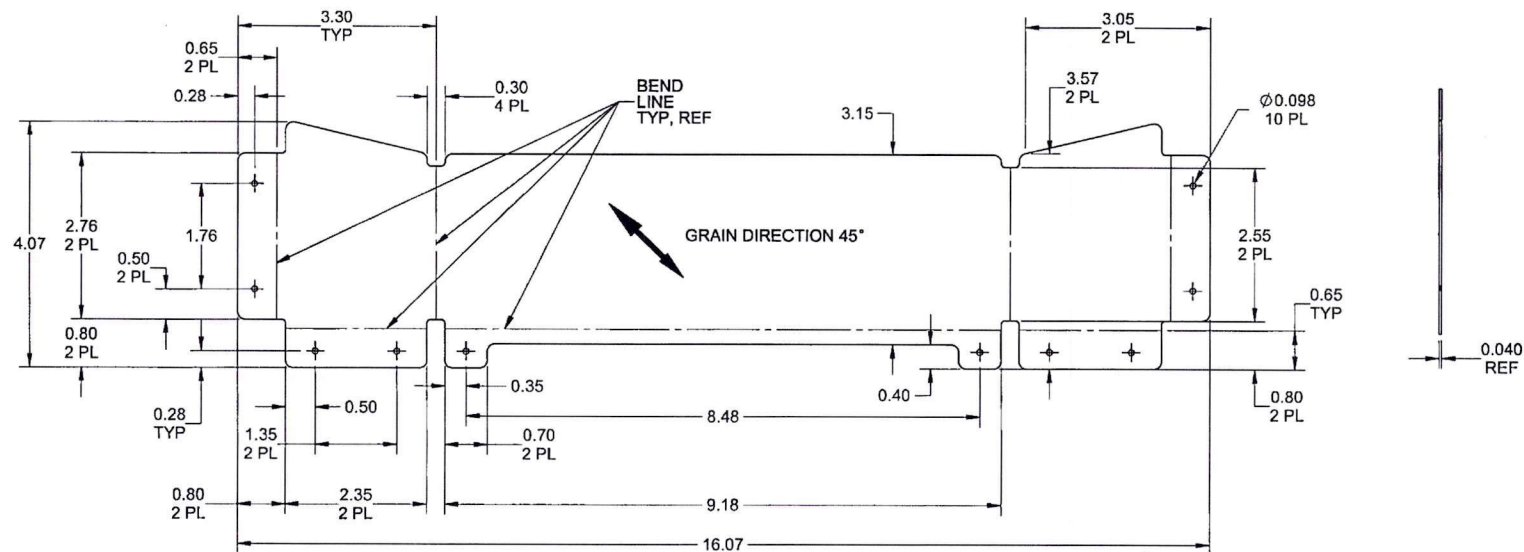
- 1) MATERIAL: MAKE FROM D5076-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.21 lbs

RELEASED

2015 OCT 19

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	PM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5076	SHEET 9 OF 12
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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D5076-3F FLAT PATTERN BRACKET

NOTES:

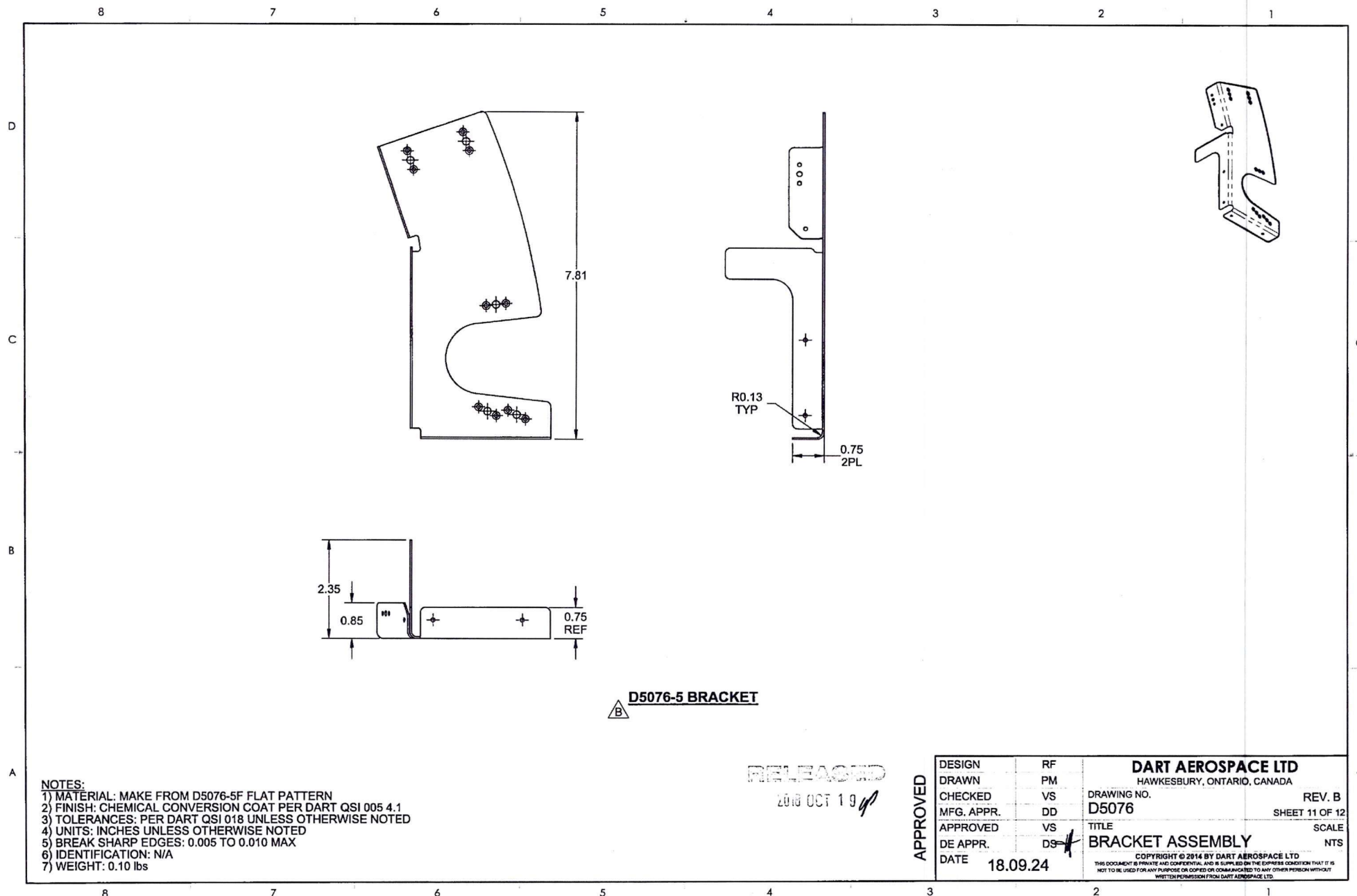
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
 PER QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027
 OR ASTM B209
 REF DART SPEC. M6061T6S.040

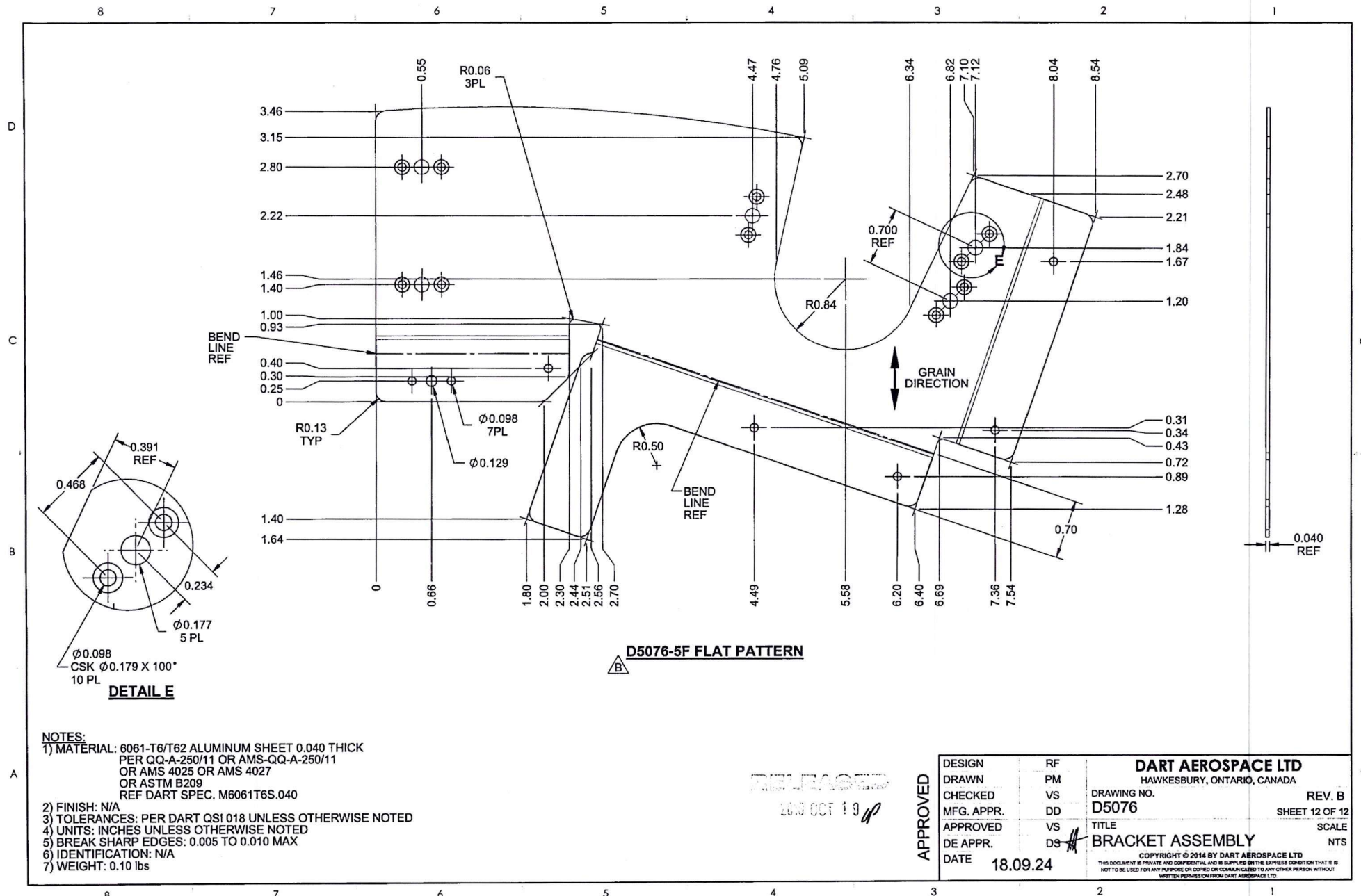
2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.21 lbs

RELEASED
 10 OCT 10

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	PM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5076	SHEET 10 OF 12
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S156554



Part: D5076-047

Job No: 188882

Serial No/Batch: S156554

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/26/19